

Work Order ID 120433

120433

Page 1

Wednesday, June 04, 2014 3:05:01 PM

Item ID: D3417-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 6/04/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLD

Date: 14-06-06

Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev F								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA761 Rev: AA & Dwg D3417 Rev: F 2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120	Memo	0.00							
QC									
Quality Control									

DAS

40

9-89

14/06/10

DAS

40

9-89

14/06/10

DAS

20

9-89

14-06-11

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Work Order ID 120433

120433

Page 2

Wednesday, June 04, 2014 3:05:01 PM

Item ID: D3417-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Washer

Stop

NS2

Start Date: 6/04/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: <u>ST 38</u>	0.00							
Packaging	Memo	0.00							

DAS
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

MLJ 14-06-12

140

QC

Quality Control

Memo

0.00

AT 14-06-11

DQA: _____ Date: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Picklist Print

Page 1

Wednesday, June 04, 2014 3:05:00 PM

Work Order ID: 120433

120433
D3417-5

Parent Item: D3417-5

Parent Item Name: Washer

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			110	f	23.0000	0.0296	0.311579			DAS
MDFI RINR1 2500									**			14/06/10	40 9.89

DELRIN ROUND BAR 1.25" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT → m128113	23 23	43

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATEWork Order update only 

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
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Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending	Bend	Folio/Program							
	Centre Not Concentric	BOM/Route	Grain							
	Cracks	Broken/Damage/Defect	Hardware							
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified							
	Cuffs	Contamination	Instructions Incomplete/Unclear							
	Crushing	Countersink	Misaligned/off center							
	Heat Treat	Cut Too Short	Mislabeled							
	Inspection Strip in Tube	Drawing	Misread							
	Marks/Chatter	Drill Holes	Off-set							
	Turning Sequence	Finish	Out of Calibration							
	Wave/Twist in Tube	Fit/Function	Out of Sequence							

DART AEROSPACE LTD	Work Order:	120433
Description: Washer	Part Number:	D3417-5
Inspection Dwg: D3417	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

DAS

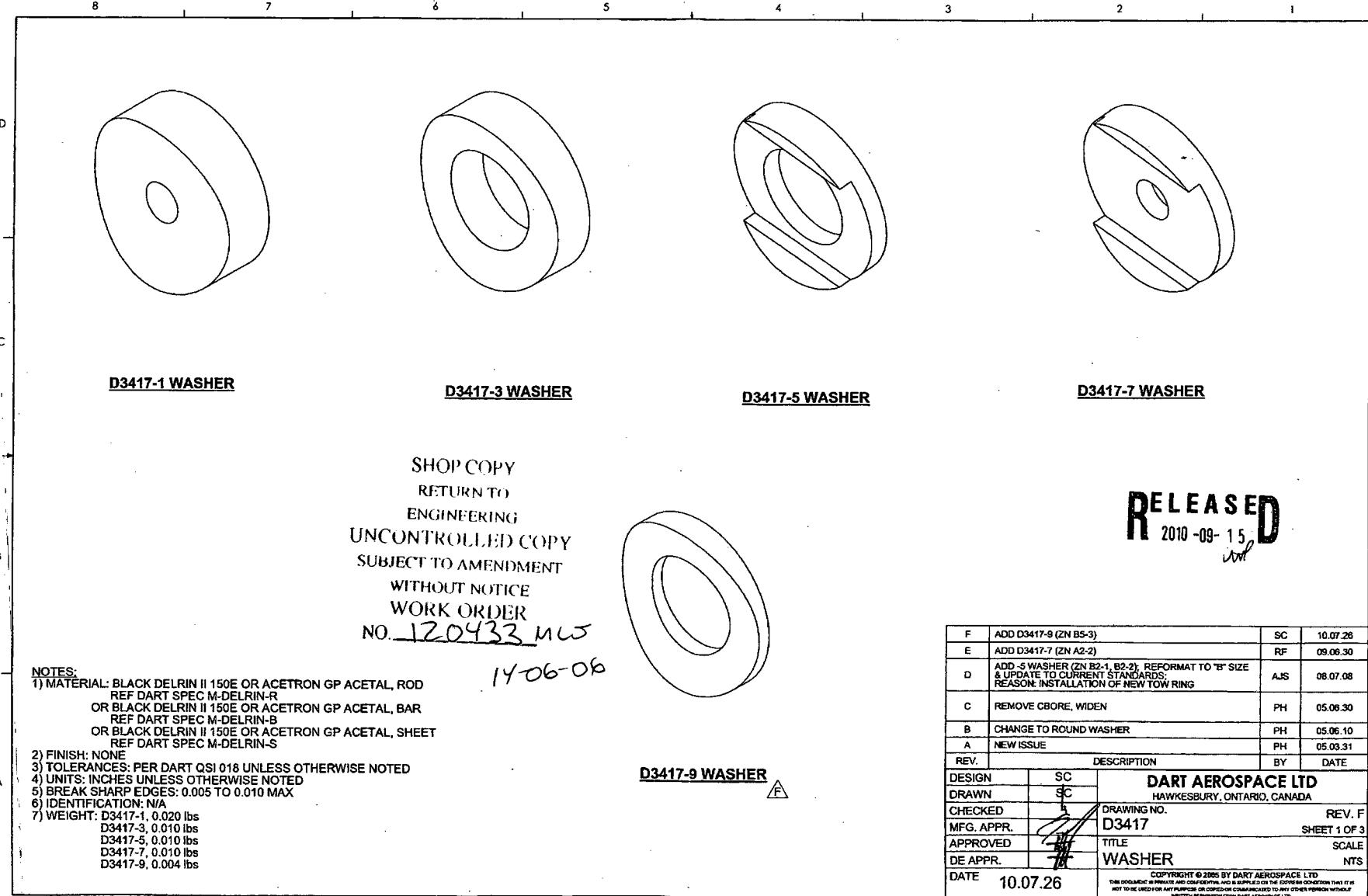
DAS

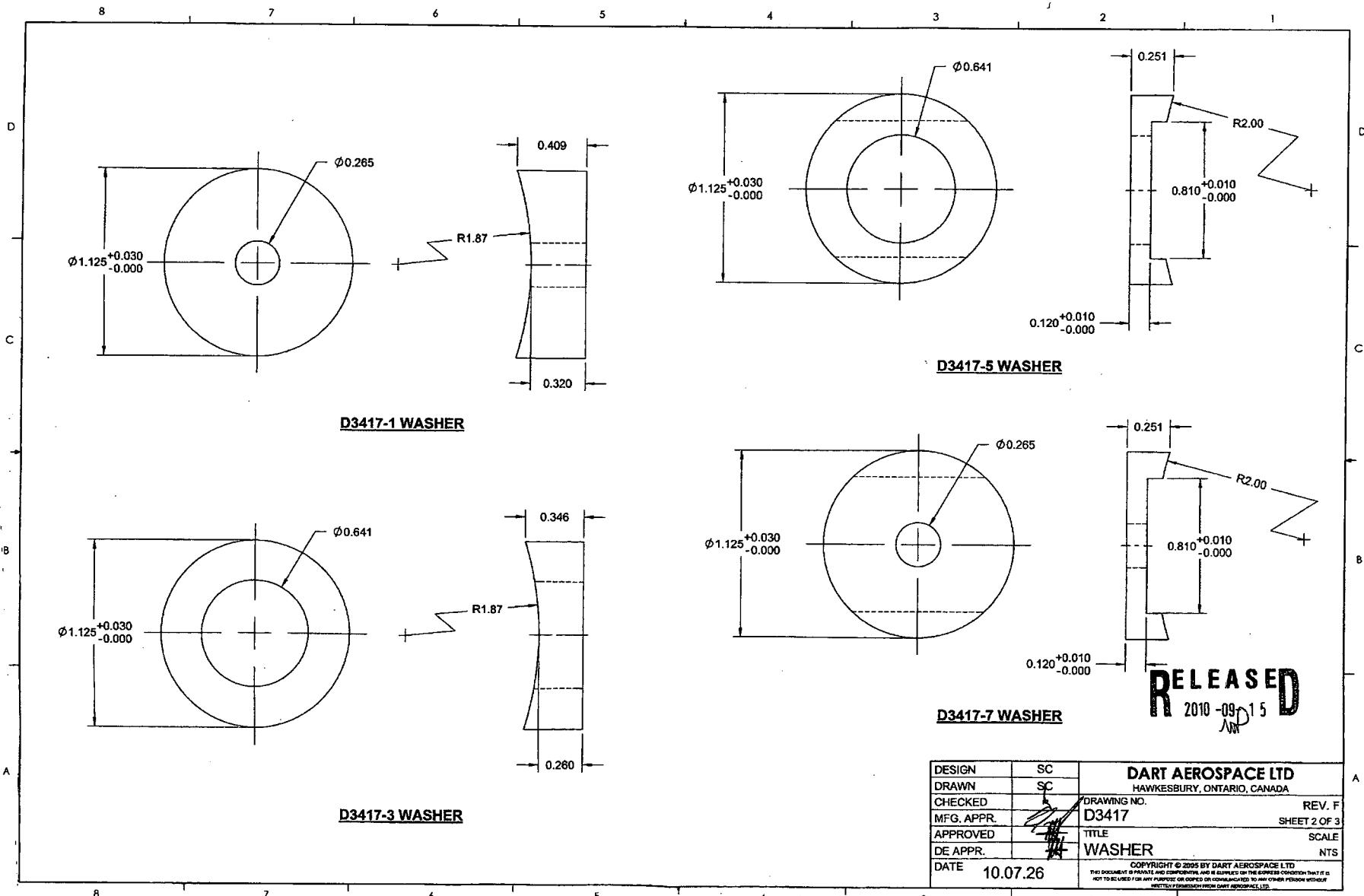
Measured by:	40 9-09
Date:	14/06/10

Audited by:	20 9-89
Date:	14-06-11

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	10.11.12	Dwg Rev updated	KJ	
C	12.07.31	Dwg Rev updated	KJ	(S) (J)





DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3417	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR COPIED IN WHOLE OR IN PART, OR OTHERWISE COMMUNICATED TO ANY OTHER PERSON UNLESS WRITTEN PERMISSION FROM DART AEROSPACE LTD	

